

B 95710

**\*95710\***

Page 1

**Work Order ID 95710**

January-18-13 10:02:02 AM

Item ID: D2174-1

Accept

**\*N900040100\***Setup Start **\*NS1\***Revision ID: **D2174-1**Stop **\*NS2\***

Item Name: Web

Start Date: 1/28/13 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 1/28/13 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Run Start **\*NR1\***Approvals: Process Plan: MLJ Date: 13-01-18 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_Stop **\*NR2\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D2174

Rev E

100

0.00

**\*100\***

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2174 Dwg Rev: E Prog Rev: E 2-  
Debur if necessary

2024.063

6 0 Jm13-09-27

110

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*110\***

QC

Memo

0.00

Quality Control

6 0 Jm13-09-27

120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

Memo

0.00

Quality Control

DAS

27

9-89

B9276

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

|  |   |   |                                      |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |
|--|---|---|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____ | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Work Order Update <input type="checkbox"/> | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/>   | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> |  |
| Skid-tube <input type="checkbox"/>                           | Crosstube <input type="checkbox"/>  | Water Jet <input type="checkbox"/>  | Engineering <input type="checkbox"/> |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |
| Machining <input type="checkbox"/>                           | Small Fab <input type="checkbox"/>  | Prod. Eng. Coord. <input type="checkbox"/>  | Quality <input type="checkbox"/>     |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |
| Thermoforming <input type="checkbox"/>                       | Finishing <input type="checkbox"/>  | Rec/Store/Packaging <input type="checkbox"/>  | Other <input type="checkbox"/>       |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |
| Large Fab <input type="checkbox"/>                           | Composite <input type="checkbox"/>  | Supplier <input type="checkbox"/>   |                                      |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |

| Root Cause    | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Doc/Data      |      |      |     |   |                   |                    |             |              |              |
| Equip/Tooling |      |      |     |   |                   |                    |             |              |              |
| Operator      |      |      |     |   |                   |                    |             |              |              |
| Material      |      |      |     |   |                   |                    |             |              |              |
| Setup         |      |      |     |   |                   |                    |             |              |              |
| Other         |      |      |     |   |                   |                    |             |              |              |
| Process       |      |      |     |   |                   |                    |             |              |              |
| Supplier      |      |      |     |   |                   |                    |             |              |              |
| Training      |      |      |     |   |                   |                    |             |              |              |
| Unapproved    |      |      |     |   |                   |                    |             |              |              |

**FAULT CATEGORY**

| Landing Gear  | General                                 | Other  |
|---|---|--|
| <input type="checkbox"/> Bending                      | <input type="checkbox"/> Bend           | <input type="checkbox"/> Grain                           |
| <input type="checkbox"/> Centre Not Concentric to O/S | <input type="checkbox"/> BOM/Route      | <input type="checkbox"/> Hardware                        |
| <input type="checkbox"/> Cracks                       | <input type="checkbox"/> Broken/Damaged | <input type="checkbox"/> Inspection Incomplete           |
| <input type="checkbox"/> Crushed/Crimped              | <input type="checkbox"/> Burrs          | <input type="checkbox"/> Instructions Incomplete/Unclear |
| <input type="checkbox"/> Cuffs                        | <input type="checkbox"/> Contamination  | <input type="checkbox"/> Maintenance                     |
| <input type="checkbox"/> Heat Treat                   | <input type="checkbox"/> Countersink    | <input type="checkbox"/> Mislabeled                      |
| <input type="checkbox"/> Inspection Strip in Tube     | <input type="checkbox"/> Cut Too Short  | <input type="checkbox"/> Misread                         |
| <input type="checkbox"/> Ripples in Bend              | <input type="checkbox"/> Drill Holes    | <input type="checkbox"/> Offset                          |
| <input type="checkbox"/> Torque Waves in Extrusion    | <input type="checkbox"/> Drawing        | <input type="checkbox"/> Out of Calibration              |
| <input type="checkbox"/> Turning Sequence             | <input type="checkbox"/> Finish         | <input type="checkbox"/> Out of Sequence                 |
| <input type="checkbox"/> Wave/Twist in Tube           | <input type="checkbox"/> Folio          | <input type="checkbox"/> Outside Dimensions              |
|   |   | <input type="checkbox"/> Ovalized                        |
|   |   | <input type="checkbox"/> Over/Under tolerance            |
|   |   | <input type="checkbox"/> Part Incorrect                  |
|   |   | <input type="checkbox"/> Part Lost/Missing               |
|   |   | <input type="checkbox"/> Part Moved                      |
|   |   | <input type="checkbox"/> Positioned Wrong                |
|   |   | <input type="checkbox"/> Power Loss/Surge                |
|   |   | <input type="checkbox"/> Pressure/Forced                 |
|   |   | <input type="checkbox"/> Temperature/Cure                |
|   |   | <input type="checkbox"/> Weld                            |
|   |   | <input type="checkbox"/> Wrong Stock Pulled              |
|   |   | <input type="checkbox"/> Other                           |

# Work Order ID 95710

**\*95710\***

Page 2

January-18-13 10:02:02 AM

Item ID: D2174-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Web

Start Date: 1/28/13 Start Qty: 6.00 **\*6\***

Cust Item ID:

Required Date: 1/28/13 Req'd Qty: 6.00 **\*6\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description                      | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130                            | Small Fab                                     | 0.00                 |         |        |              |               |               |                  |                |
| <b>*130*</b>                   |   |                      |         |        |              |               |               |                  |                |
| Small Fab                      | Memo  | 0.00                 |         |        |              |               |               |                  |                |
| Small Fab                      | Debur Stack                                   |                      |         |        |              |               |               |                  |                |
|                                |   |                      |         |        |              |               |               |                  |                |
| 140                            | QC5- Inspect part completeness to step on W/O | 0.00                 |         |        |              |               |               |                  |                |
| <b>*140*</b>                   |   |                      |         |        |              |               |               |                  |                |
| QC                             | Memo  | 0.00                 |         |        |              |               |               |                  |                |
| Quality Control                |   |                      |         |        |              |               |               |                  |                |
|                                |   |                      |         |        |              |               |               |                  |                |
| 150                            | Chemical Conversion Coat per QSI005 4.1       | 0.00                 |         |        |              |               |               |                  |                |
| <b>*150*</b>                   |   |                      |         |        |              |               |               |                  |                |
| HandFinish                     | Memo  | 0.00                 |         |        |              |               |               |                  |                |
| Hand Finishing                 |   |                      |         |        |              |               |               |                  |                |

N/A

DAS  
27  
9-89

6 7613-10-1

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

|  |      |      |   |   |                   |   |             |              |   |  |  |
|--|------|------|---|---|-------------------|---|-------------|--------------|---|--|--|
| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____   |      |      |   | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Work Order Update <input type="checkbox"/> |                   | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Thermoforming <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/><br/>           Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/><br/>           Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Quality <input type="checkbox"/><br/>           Other <input type="checkbox"/> </div> </div> |             |              |   |  |  |
| <b>Root Cause</b>  | Date | Step | Qty   | Description of work order update or Non-conformance   | Initial Chief Eng | Action Description  | Sign & Date | Verification | QC Inspector  |  |  |
| Doc/Data <input type="checkbox"/>  |      |      |   |   |                   |   |             |              |   |  |  |
| Equip/Tooling <input type="checkbox"/>   |      |      |   |   |                   |   |             |              |   |  |  |
| Operator <input type="checkbox"/>  |      |      |   |   |                   |   |             |              |   |  |  |
| Material <input type="checkbox"/>  |      |      |   |   |                   |   |             |              |   |  |  |
| Setup <input type="checkbox"/>   |      |      |   |   |                   |   |             |              |   |  |  |
| Other <input type="checkbox"/>   |      |      |   |   |                   |   |             |              |   |  |  |
| Process <input type="checkbox"/>   |      |      |   |   |                   |   |             |              |   |  |  |
| Supplier <input type="checkbox"/>  |      |      |   |   |                   |   |             |              |   |  |  |
| Training <input type="checkbox"/>  |      |      |   |   |                   |   |             |              |   |  |  |
| Unapproved <input type="checkbox"/>  |      |      |   |   |                   |   |             |              |   |  |  |
| <b>FAULT CATEGORY</b>  |      |      |   |   |                   |   |             |              |   |  |  |
| <b>Landing Gear</b><br><input type="checkbox"/> Bending<br><input type="checkbox"/> Centre Not Concentric to O/S<br><input type="checkbox"/> Cracks<br><input type="checkbox"/> Crushed/Crimped.<br><input type="checkbox"/> Cuffs<br><input type="checkbox"/> Heat Treat<br><input type="checkbox"/> Inspection Strip in Tube<br><input type="checkbox"/> Ripples in Bend<br><input type="checkbox"/> Torque Waves in Extrusion<br><input type="checkbox"/> Turning Sequence<br><input type="checkbox"/> Wave/Twist in Tube |      |      | <b>General</b><br><input type="checkbox"/> Bend<br><input type="checkbox"/> BOM/Route<br><input type="checkbox"/> Broken/Damaged<br><input type="checkbox"/> Burrs<br><input type="checkbox"/> Contamination<br><input type="checkbox"/> Countersink<br><input type="checkbox"/> Cut Too Short<br><input type="checkbox"/> Drill Holes<br><input type="checkbox"/> Drawing<br><input type="checkbox"/> Finish<br><input type="checkbox"/> Folio |   |                   | <input type="checkbox"/> Grain<br><input type="checkbox"/> Hardware<br><input type="checkbox"/> Inspection Incomplete<br><input type="checkbox"/> Instructions Incomplete/Unclear<br><input type="checkbox"/> Maintenance<br><input type="checkbox"/> Mislabeled<br><input type="checkbox"/> Misread<br><input type="checkbox"/> Offset<br><input type="checkbox"/> Out of Calibration<br><input type="checkbox"/> Out of Sequence<br><input type="checkbox"/> Outside Dimensions   |             |              | <input type="checkbox"/> Ovalized<br><input type="checkbox"/> Over/Under tolerance<br><input type="checkbox"/> Part Incorrect<br><input type="checkbox"/> Part Lost/Missing<br><input type="checkbox"/> Part Moved<br><input type="checkbox"/> Positioned Wrong<br><input type="checkbox"/> Power Loss/Surge<br><br><input type="checkbox"/> Pressure/Forced<br><input type="checkbox"/> Temperature/Cure<br><input type="checkbox"/> Weld<br><input type="checkbox"/> Wrong Stock Pulled<br><br><input type="checkbox"/> Other |  |  |

# Work Order ID 95710

\*95710\*

Page 3

January-18-13 10:02:02 AM

Item ID: D2174-1 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Web  
 Start Date: 1/28/13 Start Qty: 6.00 \*6\* Cust Item ID:  
 Required Date: 1/28/13 Req'd Qty: 6.00 \*6\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

|                 |                         |      |  |  |  |  |  |  |  |
|-----------------|-------------------------|------|--|--|--|--|--|--|--|
| 160             | QC3 Inspect Part Finish | 0.00 |  |  |  |  |  |  |  |
| *160*           |                         |      |  |  |  |  |  |  |  |
| QC              | Memo                    | 0.00 |  |  |  |  |  |  |  |
| Quality Control |                         |      |  |  |  |  |  |  |  |

|           |   |      |  |  |  |  |  |  |  |
|-----------|---|------|--|--|--|--|--|--|--|
| 170       | Identify as per dwg & Stock Location <u>G-A</u> | 0.00 |  |  |  |  |  |  |  |
| *170*     |   |      |  |  |  |  |  |  |  |
| Packaging | Memo  | 0.00 |  |  |  |  |  |  |  |
| Packaging |   |      |  |  |  |  |  |  |  |

|                 |   |      |  |  |  |  |  |  |  |
|-----------------|---|------|--|--|--|--|--|--|--|
| 180             | QC21- Final Inspection - Work Order Release | 0.00 |  |  |  |  |  |  |  |
| *180*           |   |      |  |  |  |  |  |  |  |
| QC              | Memo  | 0.00 |  |  |  |  |  |  |  |
| Quality Control |   |      |  |  |  |  |  |  |  |

13-10-2

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

|  |      |      |     |   |                   |   |             |              |              |  |  |
|--|------|------|-----|---|-------------------|---|-------------|--------------|--------------|--|--|
| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____ |      |      |     | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Work Order Update <input type="checkbox"/> |                   | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Thermoforming <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/><br/>           Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/><br/>           Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Quality <input type="checkbox"/><br/>           Other <input type="checkbox"/> </div> </div> |             |              |              |  |  |
| <b>Root Cause</b>  | Date | Step | Qty | Description of work order update or Non-conformance   | Initial Chief Eng | Action Description  | Sign & Date | Verification | QC Inspector |  |  |
| Doc/Data <input type="checkbox"/>                            |      |      |     |   |                   |   |             |              |              |  |  |
| Equip/Tooling <input type="checkbox"/>                       |      |      |     |   |                   |   |             |              |              |  |  |
| Operator <input type="checkbox"/>                            |      |      |     |   |                   |   |             |              |              |  |  |
| Material <input type="checkbox"/>                            |      |      |     |   |                   |   |             |              |              |  |  |
| Setup <input type="checkbox"/>                               |      |      |     |   |                   |   |             |              |              |  |  |
| Other <input type="checkbox"/>                               |      |      |     |   |                   |   |             |              |              |  |  |
| Process <input type="checkbox"/>                             |      |      |     |   |                   |   |             |              |              |  |  |
| Supplier <input type="checkbox"/>                            |      |      |     |   |                   |   |             |              |              |  |  |
| Training <input type="checkbox"/>                            |      |      |     |   |                   |   |             |              |              |  |  |
| Unapproved <input type="checkbox"/>                          |      |      |     |   |                   |   |             |              |              |  |  |

| FAULT CATEGORY  |  |  |   |  |  |   |  |  |  |  |   |
|---|--|--|---|--|--|---|--|--|--|--|---|
| <b>Landing Gear</b><br><input type="checkbox"/> Bending<br><input type="checkbox"/> Centre Not Concentric to O/S<br><input type="checkbox"/> Cracks<br><input type="checkbox"/> Crushed/Crimped<br><input type="checkbox"/> Cuffs<br><input type="checkbox"/> Heat Treat<br><input type="checkbox"/> Inspection Strip in Tube<br><input type="checkbox"/> Ripples in Bend<br><input type="checkbox"/> Torque Waves in Extrusion<br><input type="checkbox"/> Turning Sequence<br><input type="checkbox"/> Wave/Twist in Tube |  |  | <b>General</b><br><input type="checkbox"/> Bend<br><input type="checkbox"/> BOM/Route<br><input type="checkbox"/> Broken/Damaged<br><input type="checkbox"/> Burrs<br><input type="checkbox"/> Contamination<br><input type="checkbox"/> Countersink<br><input type="checkbox"/> Cut Too Short<br><input type="checkbox"/> Drill Holes<br><input type="checkbox"/> Drawing<br><input type="checkbox"/> Finish<br><input type="checkbox"/> Folio |  |  | <input type="checkbox"/> Grain<br><input type="checkbox"/> Hardware<br><input type="checkbox"/> Inspection Incomplete<br><input type="checkbox"/> Instructions Incomplete/Unclear<br><input type="checkbox"/> Maintenance<br><input type="checkbox"/> Mislabeled<br><input type="checkbox"/> Misread<br><input type="checkbox"/> Offset<br><input type="checkbox"/> Out of Calibration<br><input type="checkbox"/> Out of Sequence<br><input type="checkbox"/> Outside Dimensions |  |  | <input type="checkbox"/> Ovalized<br><input type="checkbox"/> Over/Under tolerance<br><input type="checkbox"/> Part Incorrect<br><input type="checkbox"/> Part Lost/Missing<br><input type="checkbox"/> Part Moved<br><input type="checkbox"/> Positioned Wrong<br><input type="checkbox"/> Power Loss/Surge |  | <input type="checkbox"/> Pressure/Forced<br><input type="checkbox"/> Temperature/Cure<br><input type="checkbox"/> Weld<br><input type="checkbox"/> Wrong Stock Pulled<br><br><input type="checkbox"/> Other |

# Picklist Print

January-18-13 10:02:02 AM

Page 1

Work Order ID: 95710

Parent Item: D2174-1

Parent Item Name: Web

Start Date: 1/28/13

Required Date: 1/28/13

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP C04.06.09ReformatKJ/RF  
IPP Rev:D As per Rev E 06-11-22 JLM

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand  | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|-----------------|-------------|--------------|---------------|----------------|--------|
| M2024T3S.063                    |                        | Purchased     | No          |                     |                  | 100             | sf                 | 212.7400        | 0.4722      | 2.9823156    |               |                |        |
|                                 |                        |               |             |                     |                  |                 |                    |                 |             |              | 30            | JM 13-02-27    |        |
|                                 |                        |               |             | <u>Location</u>     |                  |                 | <u>Loc Qty</u>     | <u>Loc Code</u> |             |              |               |                |        |
|                                 |                        |               |             | MAT022              |                  |                 | 212.74             |                 |             |              |               |                |        |
|                                 |                        |               |             | 119916              |                  |                 | 0.2                |                 |             |              |               |                |        |
|                                 |                        |               |             | 121197              |                  |                 | 21.34              |                 |             |              |               |                |        |
|                                 |                        |               |             | 123096              |                  |                 | 11.4               |                 |             |              |               |                |        |
|                                 |                        |               |             | 123654              |                  |                 | 12.8               |                 |             |              |               |                |        |
|                                 |                        |               |             | 123701              |                  |                 | 167                |                 | 123701      |              |               |                |        |

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

|   |      |      |   |   |                   |   |             |              |  |  |   |
|---|------|------|---|---|-------------------|---|-------------|--------------|--|--|---|
| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____  |      |      |   | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Work Order Update <input type="checkbox"/> |                   | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Thermoforming <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/><br/>           Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/><br/>           Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Quality <input type="checkbox"/><br/>           Other <input type="checkbox"/> </div> </div> |             |              |  |  |   |
| Root Cause  | Date | Step | Qty   | Description of work order update or Non-conformance   | Initial Chief Eng | Action Description  | Sign & Date | Verification | QC Inspector   |  |   |
| Doc/Data <input type="checkbox"/>   |      |      |   |   |                   |   |             |              |  |  |   |
| Equip/Tooling <input type="checkbox"/>  |      |      |   |   |                   |   |             |              |  |  |   |
| Operator <input type="checkbox"/>   |      |      |   |   |                   |   |             |              |  |  |   |
| Material <input type="checkbox"/>   |      |      |   |   |                   |   |             |              |  |  |   |
| Setup <input type="checkbox"/>  |      |      |   |   |                   |   |             |              |  |  |   |
| Other <input type="checkbox"/>  |      |      |   |   |                   |   |             |              |  |  |   |
| Process <input type="checkbox"/>  |      |      |   |   |                   |   |             |              |  |  |   |
| Supplier <input type="checkbox"/>   |      |      |   |   |                   |   |             |              |  |  |   |
| Training <input type="checkbox"/>   |      |      |   |   |                   |   |             |              |  |  |   |
| Unapproved <input type="checkbox"/>   |      |      |   |   |                   |   |             |              |  |  |   |
| <b>FAULT CATEGORY</b>   |      |      |   |   |                   |   |             |              |  |  |   |
| <b>Landing Gear</b><br><input type="checkbox"/> Bending<br><input type="checkbox"/> Centre Not Concentric to O/S<br><input type="checkbox"/> Cracks<br><input type="checkbox"/> Crushed/Crimped<br><input type="checkbox"/> Cuffs<br><input type="checkbox"/> Heat Treat<br><input type="checkbox"/> Inspection Strip in Tube<br><input type="checkbox"/> Ripples in Bend<br><input type="checkbox"/> Torque Waves in Extrusion<br><input type="checkbox"/> Turning Sequence<br><input type="checkbox"/> Wave/Twist in Tube |      |      | <b>General</b><br><input type="checkbox"/> Bend<br><input type="checkbox"/> BOM/Route<br><input type="checkbox"/> Broken/Damaged<br><input type="checkbox"/> Burrs<br><input type="checkbox"/> Contamination<br><input type="checkbox"/> Countersink<br><input type="checkbox"/> Cut Too Short<br><input type="checkbox"/> Drill Holes<br><input type="checkbox"/> Drawing<br><input type="checkbox"/> Finish<br><input type="checkbox"/> Folio |   |                   | <input type="checkbox"/> Grain<br><input type="checkbox"/> Hardware<br><input type="checkbox"/> Inspection Incomplete<br><input type="checkbox"/> Instructions Incomplete/Unclear<br><input type="checkbox"/> Maintenance<br><input type="checkbox"/> Mislabeled<br><input type="checkbox"/> Misread<br><input type="checkbox"/> Offset<br><input type="checkbox"/> Out of Calibration<br><input type="checkbox"/> Out of Sequence<br><input type="checkbox"/> Outside Dimensions   |             |              | <input type="checkbox"/> Ovalized<br><input type="checkbox"/> Over/Under tolerance<br><input type="checkbox"/> Part Incorrect<br><input type="checkbox"/> Part Lost/Missing<br><input type="checkbox"/> Part Moved<br><input type="checkbox"/> Positioned Wrong<br><input type="checkbox"/> Power Loss/Surge |  | <input type="checkbox"/> Pressure/Forced<br><input type="checkbox"/> Temperature/Cure<br><input type="checkbox"/> Weld<br><input type="checkbox"/> Wrong Stock Pulled<br><br><input type="checkbox"/> Other |

|                       |        |              |         |
|-----------------------|--------|--------------|---------|
| DART AEROSPACE LTD    |        | Work Order:  | 95710   |
| Description: Web      |        | Part Number: | D2174-1 |
| Inspection Dwg: D2174 | Rev: E | Page 1 of 1  |         |

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance     | Actual Dimension | Accept | Reject | Method of Inspection | Comments   |
|-------------------|---------------|------------------|--------|--------|----------------------|------------|
| 6.250             | +/-0.010      | 6.260"           | -      |        | V                    | Jm         |
| 6.400             | +/-0.010      | 6.400"           | -      |        | V                    |            |
| 4.800             | +/-0.010      | 4.810"           | -      |        | V                    |            |
| 1.375             | +/-0.010      | 1.384"           | -      |        | V                    |            |
| 1.050             | +/-0.005      | 1.051"           | -      |        | V                    |            |
| Ø0.128            | +0.005/-0.001 | 0.129"           | -      |        | V                    |            |
| 12.650            | +/-0.010      | 12.680"          | -      |        | T                    | Jm         |
| 0.550             | +/-0.010      | 0.554"           | -      |        | V                    |            |
| 0.900             | +/-0.010      | 0.903"           | -      |        | V                    |            |
| 1.629             | +/-0.010      | 1.637"           | -      |        | V                    |            |
| 1.506             | +/-0.005      | 1.511"           | -      |        | V                    |            |
| 11.550            | +/-0.005      | 11.553"          | -      |        | V                    | Protractor |
| 50°               | +/-0.5°       | 50°              |        |        | Protractor           |            |
| 0.063 thick       | +/-0.010      | 0.064"           | -      |        | V                    |            |
| Ø0.172            | +0.005/-0.001 | 0.173"           | -      |        | V                    |            |
|                   |               |                  |        |        |                      |            |
|                   |               |                  |        |        |                      |            |
|                   |               |                  |        |        |                      |            |
|                   |               |                  |        |        |                      |            |
|                   |               |                  |        |        |                      |            |
|                   |               |                  |        |        |                      |            |
|                   |               |                  |        |        |                      |            |
|                   |               |                  |        |        |                      |            |

DAS

27  
9-89

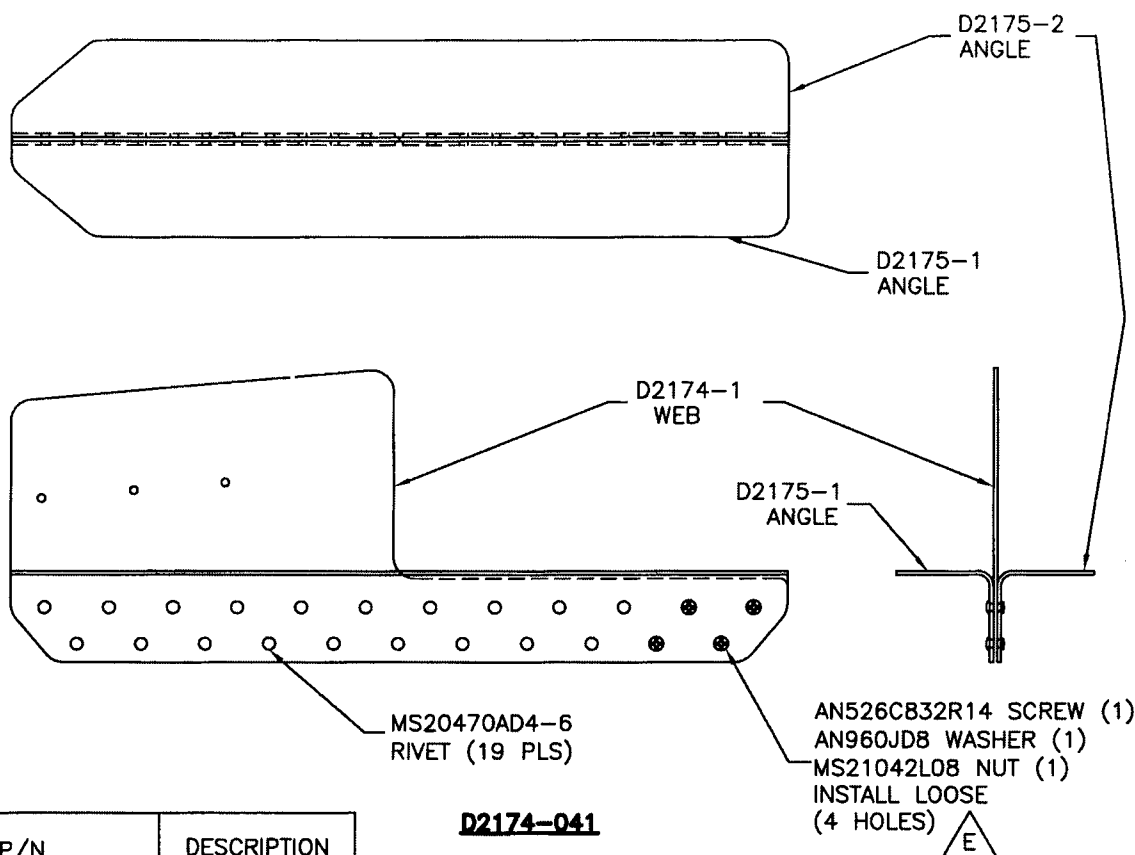
|                 |                        |                     |     |
|-----------------|------------------------|---------------------|-----|
| Measured by: Jm | Audited by: 27<br>9-89 | Prototype Approval: | N/A |
| Date: 13-09-27  | Date: 13-9-27          | Date:               | N/A |

| Rev | Date     | Change                 | Revised by | Approved |
|-----|----------|------------------------|------------|----------|
| A   | 04.08.12 | New Issue              | KJ/JLM     |          |
| B   | 07.04.02 | Ø0.172 dimension added | KJ/JLM     |          |

**DART**

NOT A COPY  
RETURN TO  
ENGINEERING  
CONTROLLED COPY  
DATE TO AMENDMENT  
BY  
ORDER  
957.10 MLW  
13-01-18

| DESIGN           | DRAWN BY       | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA | REV. E       |
|------------------|----------------|---|--------------|
| RF               | CE             |   |              |
| CHECKED<br>PH    | APPROVED<br>CH | DRAWING NO.<br>D2174                              | SHEET 1 OF 2 |
| DATE<br>06.09.25 |                | TITLE<br>WEB ASSEMBLY                             | SCALE<br>1:3 |
| A                | 95.10.25       | NEW ISSUE   |              |
| B                | 96.01.18       | RE-DRAWN  |              |
| C                | 00.09.11       | UPDATE FINISH SPEC.                               |              |
| D                | 04.06.03       | RE-DESIGN   |              |
| E                | 06.09.25       | INC 4 HOLES TO Ø0.172; CHG HARDWARE               |              |



**D2174-041**

| QTY<br>-041 | P/N          | DESCRIPTION  |
|-------------|--------------|--------------|
| X           | D2174-041    | WEB ASSEMBLY |
| 1           | D2174-1      | WEB          |
| 1           | D2175-2      | ANGLE        |
| 1           | D2175-1      | ANGLE        |
| 4           | AN526C832R14 | SCREW        |
| 4           | AN960JD8     | WASHER       |
| 4           | MS21042L08   | NUT          |
| 19          | MS20470AD4-6 | RIVET        |

**NOTES:**

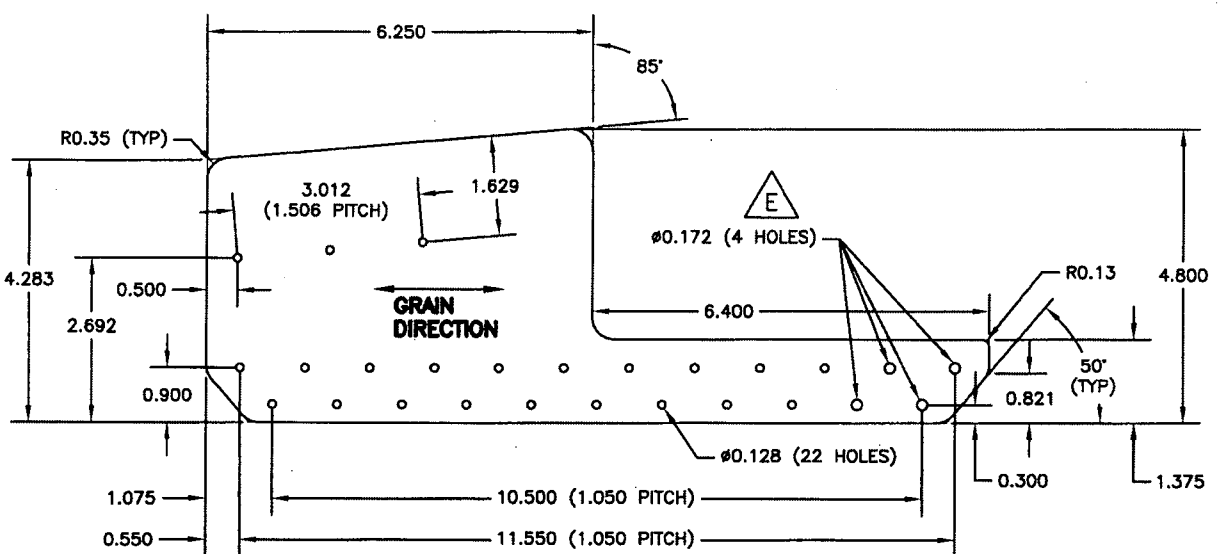
- 1) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) IDENTIFY WITH P/N D2174-041 USING FIND POINT PERMANENT INK MARKER.

**RELEASED**  
06.10.13

95710



|         |          |             |             |                             |
|---------|----------|-------------|-------------|-----------------------------|
| DESIGN  | RF       | DRAWN BY    | CE          | DART AEROSPACE LTD          |
| CHECKED | PH       | APPROVED    | [Signature] | HAWKESBURY, ONTARIO, CANADA |
| DATE    | 06.09.25 | TITLE       | WEB         | REV. E                      |
|         |          | DRAWING NO. | D2174       | SHEET 2 OF 2                |
|         |          | SCALE       | 1:3         |                             |



D2174-1

- NOTES:
- 1) MATERIAL: 2024-T3 SHEET (QQ-A-200/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
  - 5) ALL DIMENSION ARE IN INCHES

RELEASED  
06.10.23

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